

Work Order ID 83369

83369

Page 1

April-17-12 2:24:18 PM

Item ID: D2585

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Channel

Start Date: 17/04/2012 Start Qty: 30.00 ***30***

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 30.00 ***30***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/17 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2585	Rev B

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2585

304 086

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

30 0

Jm/mhl
12-4-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

30 0

Jm/mhl
12-4-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Scrub

cut
30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D2585								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

SP
12/05/12

cont
+30

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 Identify as per dwg & Stock Location: 11 0.00

160

Packaging

Memo

0.00

Packaging

170 QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.00

Quality Control

(Handwritten notes and signatures)
 30
 12/5/3
 12/05/03

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-17-12 2:24:22 PM

Page 1

Work Order ID: 83369

83369

Parent Item: D2585

D2585

Parent Item Name: Mounting Channel

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP D04.02.16Reformat; Add Receiving StepKJ/RF
IPP C 06.07.21 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	99.0400	0.0157	0.495789			

M304S14GA

**

304SS sheet .080

Location

Loc Qty

Loc Code

MAT020

99.04

117933

6.6

119276

92.44

119276 0.5

Jm
12-4-29

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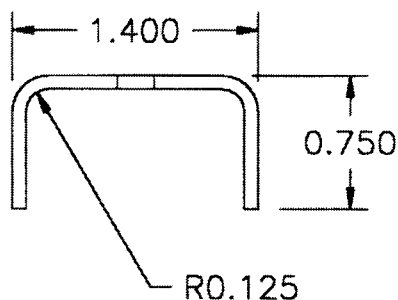
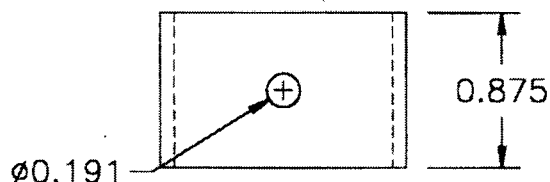
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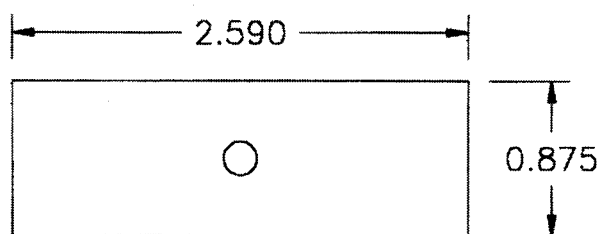


DESIGN BW	DRAWN BY MS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96:07:11		TITLE MOUNTING CHANNEL	SCALE 1:1
B	97:03:14	ADD FLAT PATTERN	

RELEASED
97/03/14 DS



FLAT PATTERN



MATERIAL: 304/316 SS, 14 GAUGE (0.078)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83369
12/04/12

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